Thursday, 4/5/2007 11:59:36 AM Date Kim Johnston User: **Process Sheet Drawing Name** : DOOR ASSEMBLY : CU-DAR001 Dart Helicopters Services Customer Job Number : 31703 **Estimate Number** : 10712 : NIA Part Number : D32133 P.O. Number · D3213 REV A S.O. No. : NIX : 4/5/2007 **Drawing Number** This Issue : N/A Project Number Prsht Rev. : MA : SMALL /MED FAB Type **Drawing Revision** First Issue : NA : 31433 Material Previous Run : 4/22/2007 Each Qty: 10 Um: **Due Date** Written By 🗓 Checked & Approved By 05-11-17 JLM New Issue Comment ... Now on Waterjet 07-02-13 JLM Est Rev:B Additional Product Job Number:----Description: ⊲Seq. #: ge **Machine Or Operation:** M2024T3S063 2024-T3 .063 sheet 1:0 1 4 -ii Total: 4.9497 sf(s) Comment: Qtv.: 0.4950 sf(s)/Unit 1101 Material: 2024-T3 (QQ-A-250/4) 0.063" thick Muster (M2024T3S.063)Identify as D3213-3 Chacke . Apt Batch: M103321 FLOW WATER JET 2.0 WATER JET Comment: FLOW WATER JET INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 4. 44 V .... 07 04 10 Comment: INSPECT PARTS AS THEY COME OFF MACHINE -41-A QC8 SECOND CHECK 4.0 Comment: SECOND CHECK SMALL & MEDIUM FAB RESOURCE 1 5.0 SMALL FAB 1  $P_{ij}$ Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr HAND FINISHING1 HAND FINISHING RESOURCE #1 6.0 Ç, Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1

Page 1

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W/O:			WOF	RK ORDER CH	ANGES					
DATE STEP		PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Catego	ry:	NCF	R: Yes (	0 DQA	:=	Date: _	07/04/20
						QA: N/	C Closed	:	_ Date:	
NCR:			WORK ORDEI	R NON-CONFO	RMANCE	(NCR	)			
DATE	STEP	Description of NC		orrective Action	Section B	<u> </u>	Verifica	ation	Approval	Approval
DAIL	SIEF	Section A	Initial	<ul> <li>Action Descrip</li> </ul>	tion	Sign &	Section		Chief Eng	QC Inspector

NCR:			WORK ORD	ER NON-CONFORMANO	CE (NCR)			
		Description of NC		Corrective Action Section B	· · · · · · · · · · · · · · · · · · ·	Verification	A	
DATE	STEP	Section A	Initial Chief Eng	· Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Thursday, 4/5/2007 11:59:36 AM Date: Kim Johnston User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: DOOR ASSEMBLY Job Number: 31703 Part Number: D32133 Job Number: Description: Seq. #: Machine Or Operation: INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 7.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 8.0 Comment: PACKAGING RESOURCE #1 NG Identify and Stock W) Location: GA QC21 FINAL INSPECTION/W/O RELEASE 9.0<sub>m</sub> E.C. -- Comment: FINAL INSPECTION/W/O RELEASE Seq Job Completion M Stro410

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DATE	STEP	PROCEDURE CHANGE		ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	<u> </u>	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQ	A:	Date:	
					QA: N	I/C Close	d:	_ Date: _	
NCR:		V	VORK OR	DER NON-CONFORMAI	NCE (NCF	₹)			
		Description of NC		Corrective Action Section	ı B	Verifie	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	ion C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31703
Description: Door Panel	Part Number:	D3213-3
Inspection Dwg: D3213 Rev: A		Page 1 of 1

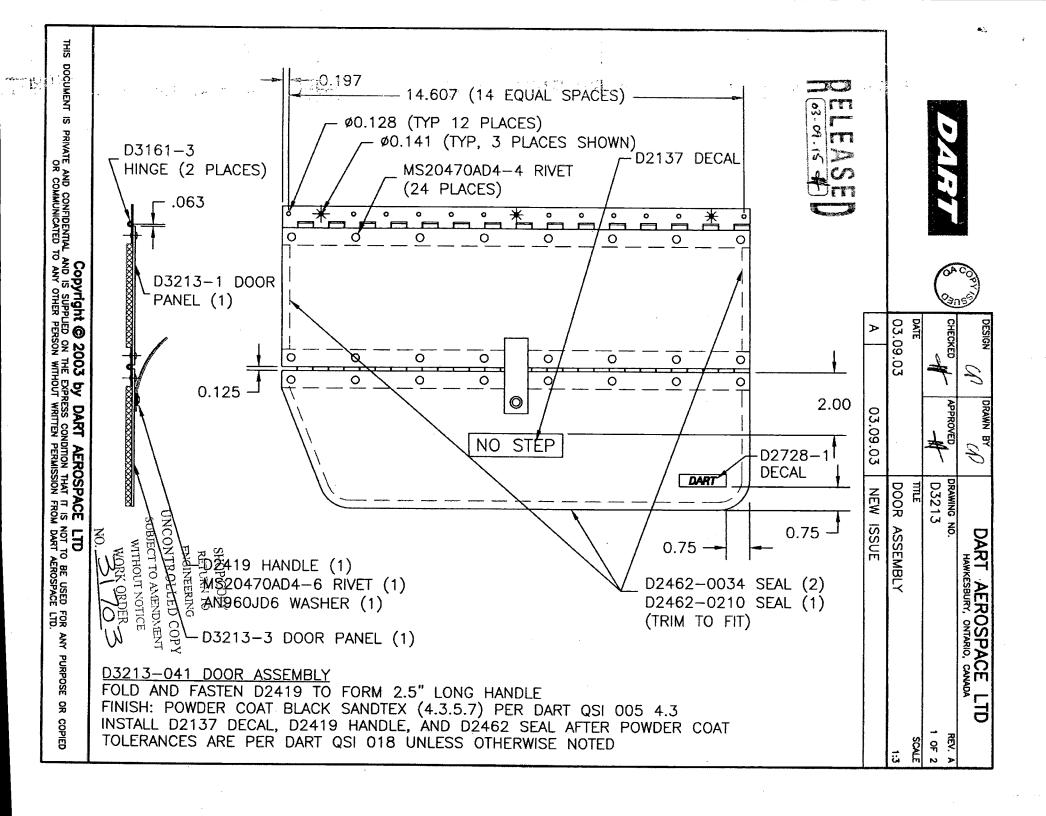
## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
15.00	+/-0.030	15.80	1		mensuring	tope
0.300	+/-0.010	0.306	J		VEVN	\
14.400	+/-0.010	14.400	1		Mansorine	tape
0.128	+0.005/-0.000	0.129	1		yend	<b>5</b>
4.42	+/-0.030	4.429	1		vern	
ງ້ອ <sup>ະ</sup> 1.00	+/-0.030	1.001	1		Vern	
0.300	+/-0.010	0.306			vern	
Pitch 2.057	+/-0.005	2.060	1		VAN	
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Measured by: M. m	Audited by:	N.	Prototype Approval:	N/A
Date: 07 04 10	Date:	07/04/10	Date:	N/A

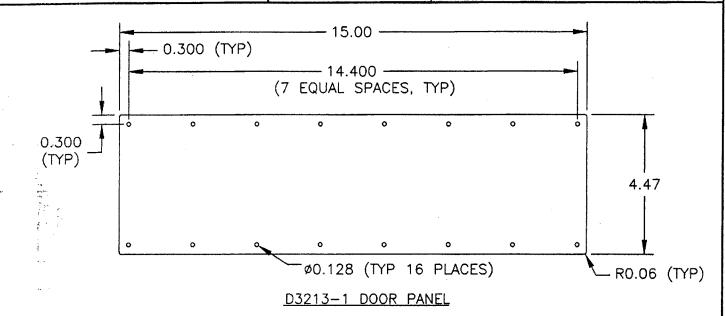
Rev	Date	Change		Revised by	Approved
Α	03.12.15	New Issue	P/O D350-567-015/-025/-031	KJ/RF	1
В	04.06.15	Tolerance cha	nged for 14.400 dimension	KJ/JLM of	

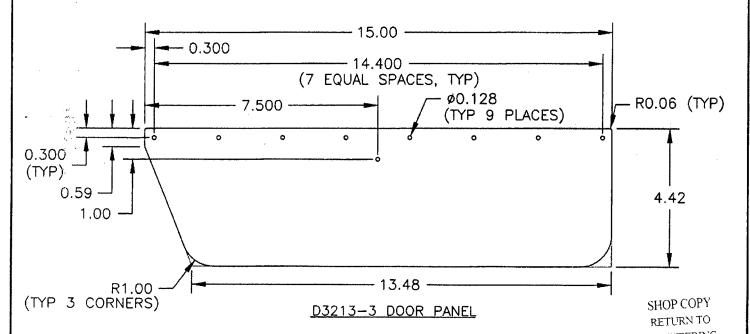






DEŞIGN (1)	DRAWN BY	DART AEROSF HAWKESBURY, ONTAI	
CHECKED	APPROVED	DRAWING NO. D3213	REV. A 2 OF 2
DATE	·	TITLE	SCALE
03.09.03		DOOR ASSEMBLY	1:3





D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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